

Work Order ID 124079

Wednesday, September 10, 2014 10:28:33 A

124079

Page 1

Item ID: D4956-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Stainless Steel Wearplate Center Fwd
 Start Date: 9/10/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-09-10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4956	A

100		0.00				13	0		DAS 23 9-89 14-09-19
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100
 Waterjet
 FLOW CNC Waterjet
 304 .040"

Memo
 1-Cut as per Dwg
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00				13	0		DAS 23 9-89 14-09-19
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110
 QC
 Quality Control

Memo

Work Order ID 124079

Wednesday, September 10, 2014 10:28:33 A

124079

Page 2

Item ID: D4956-23

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stainless Steel Wearplate Center Fwd

Start Date: 9/10/14

Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/10/14

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(13)

DAS
38
9-89 14-9-24

130

Form as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

FORM JOGGLE AS DWG

DAS
30
9-89DAS 13
36
9-89

14/09/24

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(13)

DAS
38
9-89

14-9-26

Page 3

Wednesday, September 10, 2014 10:28:33 A

Setup Start *NS1*

Revision ID:

Item Name: Stainless Steel Wearplate Center Fwd

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Date:

Run Start *NR1*

Date:

Stop ***NR2***

**Insp.
Stamp**

150

0.00

150

0.00

HandFinish

Memo

Hand Finishing

1- After finish, coat entire top (concave) surface as per note 2 dwg D4956.

TEXTURED COATING B#: 130268

DAS

41

9-89

14-9-26

160

QC3- Inspect Part Finish

0.00

160

0.00

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location:

0.00

170

0.00

Packaging

Memo

Packaging

x12

d 22 14/08/22

Work Order ID 124079

124079

Page 4

Wednesday, September 10, 2014 10:28:33 A

Item ID: D4956-23

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stainless Steel Wearplate Center Fwd

Start Date: 9/10/14

Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/10/14

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 14-09-29

14-9-29

Picklist Print

Wednesday, September 10, 2014 10:28:37 AM

Page 1

Work Order ID: 124079

124079

Parent Item: D4956-23

D4956-23

Parent Item Name: Stainless Steel Wearplate Center Fwd

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

sf

174.0319

16

DAS

23

9-89

M304S20GA

14-09-19

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

174.0318948

m126852

0.31

m127454

26.1018948

m128435

94.94

m129128

2.5

m129530

5.2

m129845

44.98

130345

130345

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

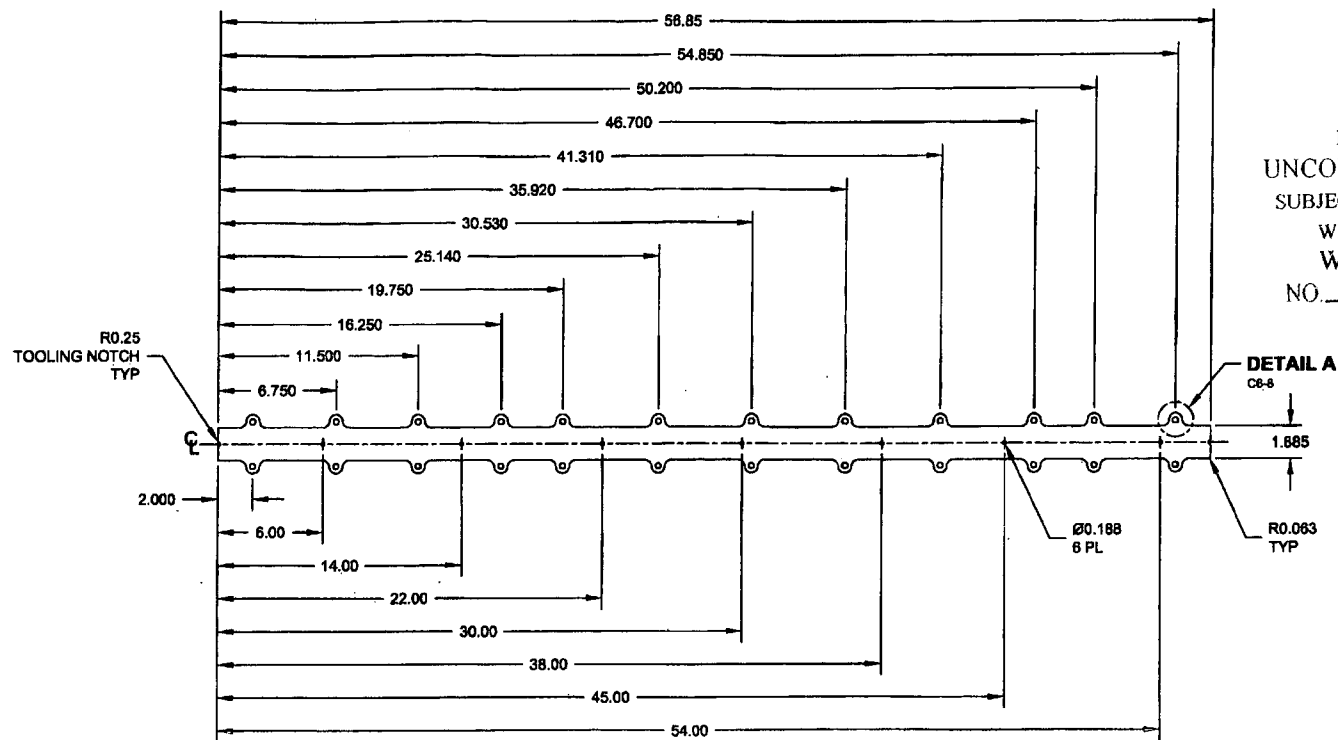
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



D4956-23F FLAT PATTERN

D4956-23 WEARSHOE
(MAKE FROM D4956-23F)

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124079
ML5
1409-10

DETAIL A
C6-B

DETAIL B
C2-B

RELEASED
2014-04-17
NP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV.
MFG. APPR.	AS	D4956	SHEET 4 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.		WEARSHOE	NT
DATE	13.09.26	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

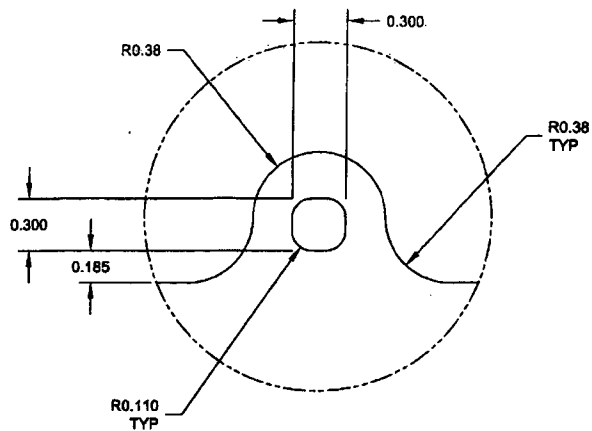
Work Order update only ☐

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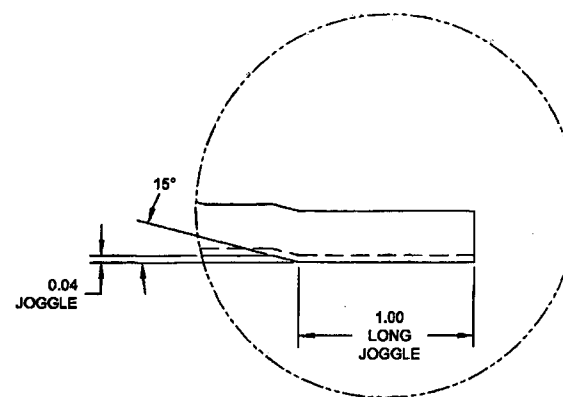
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Design									
Doc/Data									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

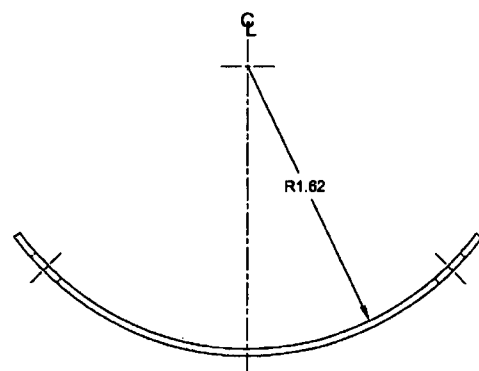
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DETAIL A C8-1 C4-1
C8-2
C8-3 C1-3
C2-4
C8-6 C2-6
C8-6 C2-6
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B6-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B8-4
B7-5 B3-6
B7-6 B3-6
B7-7 B3-7

RELEASED
2014-04-17
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AS	D4956	SHEET 8 OF 8
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DATE	13.09.26	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OFFERED OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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